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(54) Title: PROCESSES FOR THE PREPARATION OF INTERMEDIATES RELATED TO THE 5-HT_{2C} AGONIST (R)-8-CHLORO-1-METHYL-2,3,4,5-TETRAHYDRO-1H-3-BENZAZEPINE

(57) Abstract: The present invention provides processes and intermediates useful in the preparation of 8-chloro-1-methyl-2,3,4,5-tetrahydro-1H-3-benzazepine, a serotonin (5-HT) receptor agonist that is useful in the treatment or prophylaxis of, for example, central nervous system disorders, such as obesity.

**PROCESSES FOR THE PREPARATION OF INTERMEDIATES RELATED TO THE
5-HT_{2C} AGONIST (*R*)-8-CHLORO-1-METHYL-2,3,4,5-TETRAHYDRO-1*H*-3-
BENZAZEPINE**

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FIELD OF THE INVENTION

The present invention provides processes and intermediates useful in the preparation of (*R*)-8-chloro-1-methyl-2,3,4,5-tetrahydro-1*H*-3-benzazepine, a serotonin (5-HT) receptor agonist that is useful in the treatment or prophylaxis of, for example, central nervous system disorders, such as obesity.

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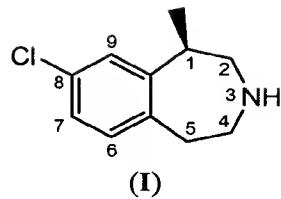
BACKGROUND OF THE INVENTION

Serotonin (5-HT) neurotransmission plays an important role in numerous physiological processes both in neurological and in psychiatric disorders. For example, 5-HT has been implicated in the regulation of feeding behavior. 5-HT is believed to work by inducing a feeling of fullness or satiety so eating stops earlier and fewer calories are consumed. It has been shown that a stimulatory action of 5-HT on the 5HT_{2C} receptor plays an important role in the control of eating. Furthermore, stimulation of the 5HT_{2C} receptor has also been shown to play an important role in the anti-obesity effect of d-fenfluramine. As the 5-HT_{2C} receptor is expressed in high density in the brain (notably in the limbic structures, extrapyramidal pathways, thalamus and hypothalamus specifically in the PVN and DMH, and predominantly in the choroid plexus) and is expressed in low density or is absent in peripheral tissues, a selective 5-HT_{2C} receptor agonist can be a more effective and safe anti-obesity agent. Also, 5-HT_{2C} knockout mice are overweight with cognitive impairment and susceptibility to seizure. Thus, the 5HT_{2C} receptor is recognized as a well-accepted receptor target for the treatment of obesity, psychiatric disorders, and other disorders.

In view of the growing demand for compounds useful in the treatment of disorders related to the 5-HT_{2C} receptor, (*R*)-8-chloro-1-methyl-2,3,4,5-tetrahydro-1*H*-3-benzazepine has emerged has an important new compound. Accordingly, new and more efficient routes leading to (*R*)-8-chloro-1-methyl-2,3,4,5-tetrahydro-1*H*-3-benzazepine and intermediates related thereto are needed. The processes and compounds described herein help meet these and other needs.

SUMMARY OF THE INVENTION

The processes and intermediates of the present invention are useful in preparing (*R*)-8-chloro-1-methyl-2,3,4,5-tetrahydro-1*H*-3-benzazepine having Formula (I):



This compound is useful in the treatment of 5-HT_{2C} receptor associated disorders, such as, obesity, and is disclosed in PCT patent publication, WO2003/086303.

5 Some embodiments of the present invention disclose processes for preparing 2-(4-chlorophenyl)ethyl bromide comprising the steps:

reacting hydrogen bromide with 2-(4-chlorophenyl)ethanol to form a reaction mixture comprising the 2-(4-chlorophenyl)ethyl bromide;

and

10 isolating the 2-(4-chlorophenyl)ethyl bromide from the reaction mixture.

Some embodiments of the present invention disclose processes for preparing 2-chloro-N-(4-chlorophenethyl)propan-1-amine hydrochloride comprising the steps:

15 a) reacting hydrogen bromide with 2-(4-chlorophenyl)ethanol to form 2-(4-chlorophenyl)ethyl bromide;

b) reacting said 2-(4-chlorophenyl)ethyl bromide with 1-aminopropan-2-ol to form 1-(4-chlorophenethylamino)propan-2-ol; and

c) reacting said 1-(4-chlorophenethylamino)propan-2-ol with thionyl chloride to form 2-chloro-N-(4-chlorophenethyl)propan-1-amine hydrochloride.

20

DETAILED DESCRIPTION OF EMBODIMENTS OF THE INVENTION

The processes and intermediates of the present invention are useful in the preparation of the therapeutic agent (R)-8-chloro-1-methyl-2,3,4,5-tetrahydro-1H-3-benzazepine, including, salts and crystal forms thereof. The compound (R)-8-chloro-1-methyl-2,3,4,5-tetrahydro-1H-3-benzazepine, including, salts and crystal forms are disclosed in PCT patent publications, WO2003/086306 and WO2006/069363.

Certain processes for the preparation of compounds of Formula (I) and salts thereof are disclosed in PCT patent publications, WO2005/019179 and WO2007/120517.

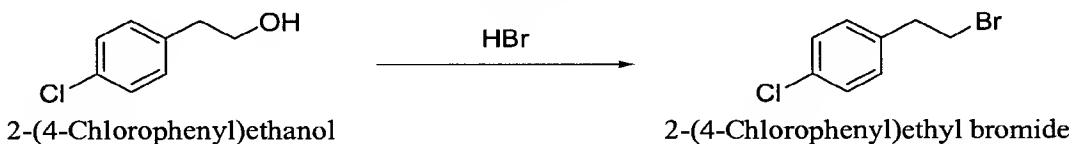
Intermediates useful in the preparation of (*R*)-8-chloro-1-methyl-2,3,4,5-tetrahydro-1*H*-3-benzazepine, HCl salts and crystal forms thereof, include 2-(4-chlorophenyl)ethyl bromide and 2-chloro-*N*-(4-chlorophenethyl)propan-1-amine hydrochloride.

Several improvements and advantages have now been discovered for the preparation of 5 each and are described herein.

Conversion of the commercially available compound 2-(4-chlorophenyl)ethanol to 2-(4-chlorophenyl)ethyl bromide with the use of HBr.

In some embodiments, 2-(4-chlorophenyl)-ethyl bromide can be prepared from the 10 commercially available compound, 2-(4-chlorophenyl)ethanol, according to the process depicted in Synthetic Scheme 1.

Synthetic Scheme 1



Accordingly, in some embodiments, the invention discloses processes for preparing 2-(4-chlorophenyl)ethyl bromide comprising reacting hydrogen bromide with 2-(4-

15 chlorophenyl)ethanol to form 2-(4-chlorophenyl)ethyl bromide.

In some embodiments, the present invention discloses processes for preparing 2-(4-chlorophenyl)ethyl bromide comprising the steps:

reacting hydrogen bromide with 2-(4-chlorophenyl)ethanol to form a reaction mixture comprising the 2-(4-chlorophenyl)ethyl bromide;

20 and

isolating the 2-(4-chlorophenyl)ethyl bromide from the reaction mixture.

In some embodiments, the reacting of hydrogen bromide with 2-(4-chlorophenyl)ethanol is conducted in the absence of an added solvent. The phrase "absence of an added solvent" is intended to mean that none or no substantial amount of solvent is added to the reaction (e.g. the reaction can be conducted "neat" in the absence of solvent). It is understood that during the reaction an equivalent amount of water is formed together with 2-(4-chlorophenyl)ethyl bromide and that this water so formed is not considered as a solvent but merely as a co-product for purposes of this definition. It is further understood that any impurity present in 2-(4-chlorophenyl)ethanol in an amount of about 5% or less as determined by HPLC 25 does not constitute "an added solvent" for the purposes of this definition.

In some embodiments, the reacting of hydrogen bromide with 2-(4-chlorophenyl)ethanol is conducted by adding the hydrogen bromide to the 2-(4-chlorophenyl)ethanol.

5 In some embodiments, the reacting of hydrogen bromide with 2-(4-chlorophenyl)ethanol is conducted by adding the hydrogen bromide as a gas to the 2-(4-chlorophenyl)ethanol.

In some embodiments, the reacting of hydrogen bromide with 2-(4-chlorophenyl)ethanol is conducted by adding the hydrogen bromide as a gas above the surface of the 2-(4-chlorophenyl)ethanol. In some embodiments, the pressure above the surface of the 2-10 (4-chlorophenyl)ethanol is about +2 bar to about ambient pressure. In some embodiments, the pressure above the surface of the 2-(4-chlorophenyl)ethanol is about +1.65 bar to about +0.5 bar.

In some embodiments, the reacting of hydrogen bromide with 2-(4-chlorophenyl)ethanol is conducted by adding the hydrogen bromide as a gas below the surface of the 2-(4-chlorophenyl)ethanol.

15 In some embodiments, the reacting of hydrogen bromide with 2-(4-chlorophenyl)ethanol is conducted at a temperature from about 25 °C to about 110 °C.

In some embodiments, the reacting of hydrogen bromide with 2-(4-chlorophenyl)ethanol is conducted at a temperature from about 60 °C to about 100 °C.

20 In some embodiments, the reacting of hydrogen bromide with 2-(4-chlorophenyl)ethanol is conducted at a temperature from about 70 °C to about 90 °C.

In some embodiments, the reacting of hydrogen bromide with 2-(4-chlorophenyl)ethanol is conducted at a pressure from about -1.00 bar to about +2.00 bar.

In some embodiments, the reacting of hydrogen bromide with 2-(4-chlorophenyl)ethanol is conducted at a pressure from about -1.00 bar to about +0.50 bar.

25 In some embodiments, the reacting of hydrogen bromide with 2-(4-chlorophenyl)ethanol is conducted at a pressure from about -0.85 bar to about +0.37 bar.

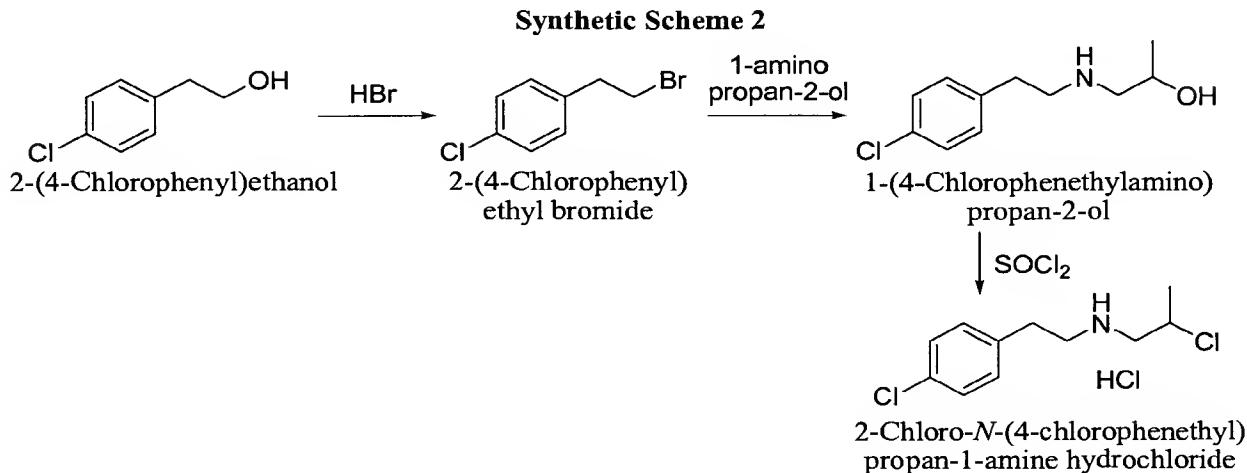
In some embodiments, isolating comprises separating the water co-product from the 2-(4-chlorophenyl)ethyl bromide.

30 In some embodiments, after the isolating step, 2-(4-chlorophenyl)ethyl bromide has a purity of about 95% or greater as determined by HPLC. In some embodiments, after the isolating step, 2-(4-chlorophenyl)ethyl bromide has a purity of about 97% or greater as determined by HPLC. The term "HPLC" refers to High Performance Liquid Chromatography. In some embodiments, "HPLC" refers to Reversed-Phase High Performance Liquid

Chromatography. In some embodiments, "HPLC" refers to Normal-Phase High Performance Liquid Chromatography.

Conversion of the commercially available compound 2-(4-chlorophenyl)ethanol to 2-chloro-N-(4-chlorophenethyl)propan-1-amine.

5 In some embodiments, 2-chloro-N-(4-chlorophenethyl)propan-1-amine hydrochloride can be prepared from 2-(4-chlorophenyl)ethanol according to the process depicted in Synthetic Scheme 2.



10 In some embodiments, the present invention discloses processes for preparing 2-chloro-N-(4-chlorophenethyl)propan-1-amine hydrochloride comprising the steps:

- a) reacting hydrogen bromide with 2-(4-chlorophenyl)ethanol to form 2-(4-chlorophenyl)ethyl bromide;
- b) reacting the 2-(4-chlorophenyl)ethyl bromide with 1-aminopropan-2-ol to form 1-(4-chlorophenethylamino)propan-2-ol; and
- c) reacting the 1-(4-chlorophenethylamino)propan-2-ol with thionyl chloride to form 2-chloro-N-(4-chlorophenethyl)propan-1-amine hydrochloride.

In some embodiments, reacting hydrogen bromide with 2-(4-chlorophenyl)ethanol is conducted in the absence of an added solvent.

20 In some embodiments, reacting hydrogen bromide with 2-(4-chlorophenyl)ethanol is conducted by adding the hydrogen bromide to the 2-(4-chlorophenyl)ethanol.

In some embodiments, reacting hydrogen bromide with said 2-(4-chlorophenyl)ethanol is conducted by adding said hydrogen bromide as a gas to said 2-(4-chlorophenyl)ethanol.

25 In some embodiments, reacting hydrogen bromide with 2-(4-chlorophenyl)ethanol is conducted at a temperature from about 25 °C to about 110 °C.

In some embodiments, reacting hydrogen bromide with 2-(4-chlorophenyl)ethanol is conducted at a temperature from about 60 °C to about 100 °C.

In some embodiments, reacting hydrogen bromide with 2-(4-chlorophenyl)ethanol is conducted at a temperature from about 70 °C to about 90 °C.

5 In some embodiments, reacting hydrogen bromide with 2-(4-chlorophenyl)ethanol is conducted at a pressure from about -1.00 bar to about +2.00 bar.

In some embodiments, reacting hydrogen bromide with 2-(4-chlorophenyl)ethanol is conducted at a pressure from about -1.00 bar to about +0.50 bar.

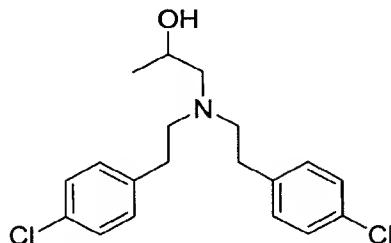
10 In some embodiments, reacting hydrogen bromide with 2-(4-chlorophenyl)ethanol is conducted at a pressure from about -0.85 bar to about +0.37 bar.

In some embodiments, reacting hydrogen bromide with 2-(4-chlorophenyl)ethanol, produces 2-(4-chlorophenyl)ethyl bromide with a purity of about 95% or greater as determined by HPLC. In some embodiments, reacting hydrogen bromide with 2-(4-chlorophenyl)ethanol, produces 2-(4-chlorophenyl)ethyl bromide with a purity of about 97% or greater as determined 15 by HPLC. In some embodiments, "HPLC" refers to Reversed-Phase High Performance Liquid Chromatography. In some embodiments, "HPLC" refers to Normal-Phase High Performance Liquid Chromatography.

In some embodiments, reacting 2-(4-chlorophenyl)ethyl bromide with 1-aminopropan-2-ol is conducted by the addition of 2-(4-chlorophenyl)ethyl bromide to 1-aminopropan-2-ol.

20 In some embodiments, reacting 2-(4-chlorophenyl)ethyl bromide with 1-aminopropan-2-ol is conducted by the addition of 2-(4-chlorophenyl)ethyl bromide to 1-aminopropan-2-ol at a rate such that 1-(bis(4-chlorophenethyl)amino)propan-2-ol is formed in an amount less than about 10% compared to 1-(4-chlorophenethylamino)propan-2-ol as determined by HPLC.

25 In some embodiments, reacting 2-(4-chlorophenyl)ethyl bromide with 1-aminopropan-2-ol is conducted by the addition of 2-(4-chlorophenyl)ethyl bromide to 1-aminopropan-2-ol at a rate such that 1-(bis(4-chlorophenethyl)amino)propan-2-ol is formed in an amount less than about 5% compared to 1-(4-chlorophenethylamino)propan-2-ol as determined by HPLC. The chemical structure for 1-(bis(4-chlorophenethyl)amino)propan-2-ol is shown below:



1-(bis(4-chlorophenethyl)amino)propan-2-ol.

In some embodiments, reacting 2-(4-chlorophenyl)ethyl bromide with 1-aminopropan-2-ol is conducted in the presence of a molar excess of 1-aminopropan-2-ol compared to 2-(4-chlorophenyl)ethyl bromide.

5 In some embodiments, reacting 2-(4-chlorophenyl)ethyl bromide with 1-aminopropan-2-ol is conducted in the presence of about 5 molar excess of 1-aminopropan-2-ol compared to 2-(4-chlorophenyl)ethyl bromide.

In some embodiments, reacting 2-(4-chlorophenyl)ethyl bromide with 1-aminopropan-2-ol is conducted at a temperature from about 60 °C to about 95 °C.

10 In some embodiments, reacting 2-(4-chlorophenyl)ethyl bromide with 1-aminopropan-2-ol is conducted at a temperature from about 75 °C to about 90 °C.

In some embodiments, reacting 1-(4-chlorophenethylamino)propan-2-ol with thionyl chloride is conducted in the presence of a solvent. In some embodiments, the solvent is an aromatic hydrocarbon. In some embodiments, the solvent comprises toluene. In some embodiments, the solvent is toluene.

15 In some embodiments, reacting 1-(4-chlorophenethylamino)propan-2-ol with thionyl chloride is conducted in the presence of dimethylacetamide (also referred to as DMA).

In some embodiments, reacting 1-(4-chlorophenethylamino)propan-2-ol with thionyl chloride is conducted in the presence of dimethylformamide (also referred to as DMF).

20 In some embodiments, reacting 1-(4-chlorophenethylamino)propan-2-ol with thionyl chloride is conducted at a temperature from about 55 °C to about 70 °C.

In some embodiments, reacting 1-(4-chlorophenethylamino)propan-2-ol with thionyl chloride is conducted at a temperature from about 60 °C to about 65 °C.

In some embodiments, the process further comprises a step of separating a water co-product from the 2-(4-chlorophenyl)ethyl bromide after step a) and prior to step b).

25 In some embodiments, wherein after step a) the resulting mixture is used in step b) without substantial purification.

In some embodiments, the process further comprises a step of removing 1-aminopropan-2-ol from the mixture after step b) and prior to step c). In some embodiments, the removing of 1-aminopropan-2-ol from the mixture after after step b) is conducted by the steps comprising:

adding water and an immiscible organic solvent to the mixture after step b) to form a biphasic mixture comprising an aqueous phase and an organic phase;

mixing the biphasic mixture and subsequently allowing to separate into the aqueous phase and the organic phase; and

removing the aqueous phase from the organic phase.

In some embodiments, the immiscible organic solvent comprises toluene.

5 In some embodiments, the immiscible organic solvent is toluene.

In some embodiments, the process further comprises a step of crystallizing the 2-chloro-*N*-(4-chlorophenethyl)propan-1-amine hydrochloride after step c). In some embodiments, crystallizing the 2-chloro-*N*-(4-chlorophenethyl)propan-1-amine hydrochloride is conducted in the presence of a mixture comprising a C₁-C₆ alcohol. In some embodiments, crystallizing the 10 2-chloro-*N*-(4-chlorophenethyl)propan-1-amine hydrochloride is conducted in the presence of a mixture comprising isopropanol.

In some embodiments, steps a), b) and c) are conducted without substantial purification and in doing so steps a), b) and c) are considered to be “telescoped” steps. The phrase “without substantial purification” is intended to mean that little or no substantial purification is utilized, 15 such as, chromatography (reverse-phase chromatography, normal-phase chromatography, flash, HPLC, MPLC, etc.), distillation (vacuum or atmospheric) of product, etc. It is understood that, 1) the mere removal of water by phase separation, where the water was either a co-product of the reaction or physically added; 2) the removal of a volatile solvent (i.e. a liquid with a boiling point of about 150 °C or less at atmospheric pressure); and 3) recrystallization and 20 crystallization, are not considered substantial purification steps for purposes of this definition.

In some embodiments, after reacting 1-(4-chlorophenethylamino)propan-2-ol with thionyl chloride, produces 2-chloro-*N*-(4-chlorophenethyl)propan-1-amine hydrochloride with a purity of about 95% or greater as determined by HPLC. In some embodiments, after reacting 1-(4-chlorophenethylamino)propan-2-ol with thionyl chloride, the 2-chloro-*N*-(4-chlorophenethyl)propan-1-amine hydrochloride with a purity of about 98% or greater as 25 determined by HPLC. In some embodiments, “HPLC” refers to Reversed-Phase High Performance Liquid Chromatography. In some embodiments, “HPLC” refers to Normal-Phase High Performance Liquid Chromatography.

30 The invention will be described in greater detail by way of specific examples. The following examples are offered for illustrative purposes, and are not intended to limit the invention in any manner. Those of skill in the art will readily recognize a variety of noncritical parameters which can be changed or modified to yield essentially the same results.

EXAMPLES

Example 1: Preparation of 2-(4-chlorophenyl)ethyl bromide from 2-(4-chlorophenyl)ethanol.

In a 1 L pressure vessel, 4-chlorophenylethanol (412.8 g, 2636 mmol) was stirred and
5 heated to an internal temperature of ~91 °C. The system was held under reduced pressure (~ - 0.98 bar) for ~2 min. Hydrogen bromide gas was gradually charged into the pressure vessel and the reaction was stirred at an internal pressure between +0.69 and +1.65 bar for 135 min. The vessel was allowed to slowly vent to a caustic scrubber and flushed with nitrogen gas for ~ 5 min. Conversion to the bromide was found to be 4.27% by HPLC. The reaction mixture was
10 allowed to cool to ambient temperature overnight under nitrogen. The mixture was then heated once more in an oil bath set at 96 °C and the vessel was evacuated. The vessel was gradually filled with hydrogen bromide gas and stirred at an internal pressure between +1.38 and +1.65 bar for 2 h. Conversion to the bromide was found to be 92.67 % by HPLC. The reaction was held at a bath temperature of 96 °C at atmospheric pressure for 45 min. The vessel was then
15 evacuated and slowly backfilled with hydrogen bromide gas over 15 min to +1.38 bar. After stirring for a further 2.5 h at +1.24 to +1.38 bar, the vessel was vented to the caustic scrubber and held at a bath temperature of 96 °C in closed system at atmospheric pressure. Conversion to the bromide was found to be 99.49% by HPLC with a peak area purity of 98.71%.

In order to test stability and impurity formation, the pressure vessel was then evacuated
20 and gradually back filled with hydrogen bromide gas to an internal pressure of +1.03 bar. The dark brown suspension was allowed to stir at +1.03 bar at a bath temperature of 96 °C. After 15 h the internal pressure had risen to +2.41 bar and the vessel was vented to the caustic scrubber, purged with nitrogen, and allowed to cool to ambient temperature. The peak area purity was found to be 96.06%. The reaction mixture was transferred to a separatory funnel and allowed to
25 separate at room temp. The upper product phase was washed with water (412 mL) in 2 portions to leave a milky beige suspension (563.4 g) with an HPLC peak area purity of 99.29%.

Example 2: Preparation of 2-(4-chlorophenyl)ethyl bromide from 2-(4-chlorophenyl)ethanol.

30 2-(4-Chlorophenyl)ethanol (1600 kg, 10.22 mol) was heated with stirring in a jacketed reactor to 70 °C. After the reactor had been evacuated to -0.85 bar and sealed, hydrogen bromide gas was bubbled into the liquid 2-(4-chlorophenyl)ethanol while allowing the heat of reaction to warm the stirred reaction mixture to 90 °C. The hydrogen bromide gas addition was continued sufficiently slowly to maintain the stirred reactor contents at 90 °C with reactor jacket cooling. When 1072 kg (13.25 mol) of hydrogen bromide gas had been added, the reactor
35 pressure was +0.37 bar, and HPLC analysis of the reaction mixture's upper organic phase revealed percentage peak areas of 96.0 and 1.63 for 2-(4-chlorophenyl)ethyl bromide and 2-(4-

chlorophenyl)ethanol respectively. The stirred reaction mixture was vented to a caustic scrubber and cooled to 30 °C. The reaction mixture was then allowed to stand for 130 min to permit phase separation. The lower aqueous HBr phase (490 kg) was drained at 29 °C. To remove as much residual hydrogen bromide as possible before the final water wash, the stirred upper 5 product phase was sparged with nitrogen at atmospheric pressure for 77 minutes at 30 °C, evacuated to -0.85 bar, sparged with nitrogen again and maintained under reduced pressure for one hour at 30 °C. Water (445 kg) was then added, and the resulting stirred mixture was sparged with nitrogen at 30 °C for 2 h. The reactor contents were then allowed to stand for 3 h to permit phase separation. The milky lower product phase was drained from the clear upper 10 aqueous phase. The upper aqueous phase weighed 465 kg. The lower product phase weighed 2190 kg (97.7% yield not corrected for assay) and was found to have an HPLC peak area purity of 98.0%.

Example 3: Preparation of 2-chloro-N-(4-chlorophenethyl)propan-1-amine

15 Hydrochloride.

In a 65 mL glass pressure vessel, 4-chlorophenylethanol (32.725 g, 209 mmol) was warmed to between 90 and 100 °C. The vessel was charged with hydrogen bromide gas and the mixture was stirred at +1.38 to +1.93 bar for 4.5 h. The pressure was released and the reaction showed 99.18% conversion by HPLC. The mixture was allowed to cool to room temperature to 20 leave 2-(4-chlorophenyl)ethyl bromide as a brown liquid (53.735 g).

Without purification, this was then added with stirring to a 100 mL round-bottom flask containing 1-aminopropan-2-ol (83 mL, 1046 mmol) at 85 °C. The clear yellow mixture was stirred at 85 to 95 °C for 2 h, at which time LCMS indicated 100% conversion. The reaction was allowed to cool to room temperature overnight and then warmed to 75 °C to form a yellow 25 oil. Water (23 mL) was added followed by toluene (96 mL) maintaining the temperature between 70 and 75 °C and the resulting mixture was stirred at this temperature for 15 min. The mixture was allowed to separate and the lower aqueous layer was extracted with toluene. The combined organic layers were concentrated to leave 1-(4-chlorophenethylamino)propan-2-ol as a yellow oil.

30 The oil was suspended in toluene (179 mL) and warmed to 50 °C to dissolve. *N,N*-Dimethylacetamide (5.88 mL, 62.7 mmol) was added followed by thionyl chloride (19.38 mL, 266 mmol) dropwise while maintaining the internal temperature at < 60 °C. On completion of the addition, the reaction was stirred at between 60 and 65 °C for 4 h. LCMS indicated 100% conversion to the chloride. The reaction was allowed to cool to room temperature and filtered. 35 The cake was washed with toluene and dried on the filter overnight. The dried solids were suspended in isopropanol (85.8 mL) and water (7.2 mL) and the stirred mixture was heated to reflux for 1 h then cooled to between 12 and 15 °C over 1 h. The mixture was stirred at this

temperature for 1 h, cooled further to 0 to 3 °C and stirred for an additional 1 h. The slurry was filtered and the cake was washed with isopropanol and dried under reduced pressure at 70 °C to leave the title compound as an off white solid (37.719 g, 67.2 %; 100% peak area purity by HPLC).

5

Example 4: Representative HPLC conditions.

Representative HPLC Condition A.

Reagents: Water (Milli-Q or equivalent), Acetonitrile (supragradient HPLC grade from Scharlau, Art.No. Ac0331, or equivalent); o-Phosphoric acid, 84-85%, r.g. from Scharlau (Art.No. Ac1100) or equivalent.

10

Run Time: 60 minutes.

Equilibration time: 8 minutes

Solvents: Acetonitrile/Water/o-Phosphoric acid (50/50/1 v/v/w).

Sample Size: 5 µL, Injection with needle-wash (solvent).

15

Column: MZ-Aqua Perfect C18, 3 pm, 250 x 4.0 mm (Supplier: EGT-Chemie AG, Art. No: 250.4, 0.0610.N).

Mobile Phase A: Water.

Mobile Phase B: Acetonitrile.

Mobile Phase C: Water/o-phosphoric acid (1 L/50 g).

20

Gradient:

Time (min)	% of A	% of B	% of C
0	76	14	10
5	76	14	10
35	74	16	10
60	0	90	10

25

Flow Rate: 1.0 mL/minute.

Temperature: 40°C

Detection wavelength: UV, 195 nm.

Representative HPLC Condition B.

30

Reagents: Water (Milli-Q or equivalent), Acetonitrile (supragradient HPLC grade from Scharlau, Art.No. Ac0331, or equivalent); Trifluoroacetic acid (TFA), HPLC grade or equivalent.

Run Time: 23 minutes.

35

Equilibration time: 8 minutes

Sample Size: 5 µL, Injection with needle-wash (solvent).

Column: Luna C18 (2), 150 x 4.6 mm, 3 µm.

Mobile Phase A: Water (0.03% TFA).

Mobile Phase B: Acetonitrile (0.025% TFA).

Gradient:

5

Time (min)	% of A	% of B
0	82	18
10	70	30
23	20	80

Flow Rate: 1.5 mL/minute.

10 **Temperature:** 35°C

Detection wavelength: UV, 220 nm.

Example 5: Preparation of 2-(4-chlorophenyl)ethyl bromide from 2-(4-chlorophenyl)ethanol.

15 The quantities in the following procedure are normalized to 1.00 kg of the starting material 2-(4-chlorophenyl)ethanol. The yield shown below is the average from four separate production runs using 1600-2400 kg of the starting material 2-(4-chlorophenyl)ethanol, the following quantities and volume ratios.

20 Starting Material and Product Quantities for 2-(4-chlorophenyl)ethyl bromide

Starting Material or Product	Mol. Wt.	Use	Kg	Mole Ratio
2-(4-chlorophenyl)ethanol	156.61	Starting Material	1.00	1.00
Hydrogen Bromide	80.91	Reagent	0.669	1.296
Water	18.02	Product Wash	0.278	
2-(4-chlorophenyl)ethyl bromide	219.51	Product	1.375	0.981

Volumes for Conversion of 2-(4-chlorophenyl)ethanol to
2-(4-chlorophenyl)ethyl bromide

L/Kg, 2-(4-chlorophenyl)ethanol		L/Kg, 2-(4-chlorophenyl)ethyl bromide	
Max.	Min.	Max.	Min.
1.670	0.864	1.215	0.629

25 To a reactor was charged 2-(4-chlorophenyl)ethanol (1.00 kg, 1.00 mol equivalent). The reactor contents were stirred and heated to 70 °C and purged with several cycles of evacuation and refilling with nitrogen. After the final evacuation, HBr gas was sparged into the stirred

reactor contents (subsurface) and the temperature of the reaction mixture was allowed to increase from about 70° C to about 90° C. The HBr gas was continued into the stirred reaction mixture at a sufficient rate to maintain the reactor pressure at or below 20 psig and the temperature of the reactor contents at about 85-95° C with reactor jacket cooling. After the HBr gas uptake slows, samples of the crude reaction mixture were obtained to determine conversion of 2-(4-chlorophenyl)ethanol to 2-(4-chlorophenyl)ethyl bromide. After the conversion was achieved [2-(4-chlorophenyl)ethanol < 2% by HPLC peak area, typically one hour after addition of 0.669 kg (1.296 mol equiv.) of HBr gas] the reactor was vented to atmospheric pressure through a caustic scrubber and cooled to approximately 30 °C. The reaction mixture was allowed to stand for about two hours to provide two phases. The lower aqueous HBr byproduct phase (0.281 kg) was drained to waste. The resulting crude product was sparged with nitrogen gas at 30° C and atmospheric pressure for about 75 minutes to remove as much residual hydrogen bromide as possible before the final water wash. The reactor was evacuated and the nitrogen sparging of nitrogen was continued through the stirred crude product at 30° C for about an hour while continuing to pull full vacuum. To the resulting crude product was charged with water (0.278 kg) the contents stirred at 30° C for 15 minutes. The stirring was stopped and the phases were allowed to separate at 30 °C over 2 to 3 hours. The lower product phase, 2-(4-chlorophenyl)ethyl bromide, 1.375 kg, 98.1% yield not corrected for assay, 98.0 area % pure by HPLC, was separated from the upper aqueous phase (0.296 kg).

Observed times required to achieve $\geq 98.4\%$ conversion of 2-(4-chlorophenyl)ethanol to 2-(4-chlorophenyl)ethyl bromide ranged from approximately 6 hours at 413 g laboratory scale to approximately 35 hours at 2400 kg scale. At 2400 kg scale, the rate-limiting factor was vaporization of HBr from the supply cylinders, not gas-liquid mass transfer in the reactor.

Various modifications of the invention, in addition to those described herein, will be apparent to those skilled in the art from the foregoing description. Such modifications are also intended to fall within the scope of the appended claims.

What is claimed is:

1. A process for preparing 2-(4-chlorophenyl)ethyl bromide comprising reacting hydrogen bromide with 2-(4-chlorophenyl)ethanol to form 2-(4-chlorophenyl)ethyl bromide.
5
2. The process according to claim 1, further comprising the step of isolating said 2-(4-chlorophenyl)ethyl bromide.
3. The process according to claim 1 or 2, wherein said reacting hydrogen bromide with 2-(4-chlorophenyl)ethanol is conducted in the absence of an added solvent.
10
4. The process according to any one of claims 1 to 3, wherein said reacting hydrogen bromide with 2-(4-chlorophenyl)ethanol is conducted by adding said hydrogen bromide to said 2-(4-chlorophenyl)ethanol.
15
5. The process according to any one of claims 1 to 3, wherein said reacting hydrogen bromide with 2-(4-chlorophenyl)ethanol is conducted by adding the hydrogen bromide as a gas below the surface of the 2-(4-chlorophenyl)ethanol.
- 20 6. The process according to any one of claims 1 to 3, wherein said reacting hydrogen bromide with said 2-(4-chlorophenyl)ethanol is conducted by adding said hydrogen bromide as a gas to said 2-(4-chlorophenyl)ethanol.
7. The process according to any one of claims 1 to 3, wherein said reacting hydrogen bromide with 2-(4-chlorophenyl)ethanol is conducted at a temperature from about 25 °C
25 to about 110 °C.
8. The process according to any one of claims 1 to 3, wherein said reacting hydrogen bromide with 2-(4-chlorophenyl)ethanol is conducted at a temperature from about 60 °C
30 to about 100 °C.
9. The process according to any one of claims 1 to 3, wherein said reacting hydrogen bromide with 2-(4-chlorophenyl)ethanol is conducted at a temperature from about 70 °C to about 90 °C.
35

10. The process according to any one of claims 1 to 9, wherein said reacting hydrogen bromide with 2-(4-chlorophenyl)ethanol is conducted at a pressure from about -1.00 bar to about +2.00 bar.
- 5 11. The process according to any one of claims 1 to 9, wherein said reacting hydrogen bromide with 2-(4-chlorophenyl)ethanol is conducted at a pressure from about -1.00 bar to about +0.50 bar.
- 10 12. The process according to any one of claims 1 to 9, wherein said reacting hydrogen bromide with 2-(4-chlorophenyl)ethanol is conducted at a pressure from about -0.85 bar to about +0.37 bar.
- 15 13. The process according to any one of claims 2 to 12, wherein said isolating comprises separating a water co-product from said 2-(4-chlorophenyl)ethyl bromide.
- 20 14. The process according to any one of claims 2 to 13, wherein after said isolating step, 2-(4-chlorophenyl)ethyl bromide has a purity of about 95% or greater as determined by HPLC.
- 25 15. The process according to any one of claims 2 to 13, wherein after said isolating step, 2-(4-chlorophenyl)ethyl bromide has a purity of about 97% or greater as determined by HPLC.
16. A process for preparing 2-chloro-N-(4-chlorophenethyl)propan-1-amine hydrochloride comprising the steps:
 - a) reacting hydrogen bromide with 2-(4-chlorophenyl)ethanol to form 2-(4-chlorophenyl)ethyl bromide;
 - b) reacting said 2-(4-chlorophenyl)ethyl bromide with 1-aminopropan-2-ol to form 1-(4-chlorophenethylamino)propan-2-ol; and
 - c) reacting said 1-(4-chlorophenethylamino)propan-2-ol with thionyl chloride to form 2-chloro-N-(4-chlorophenethyl)propan-1-amine hydrochloride.
- 30 17. The process according to claim 16, wherein said reacting hydrogen bromide with said 2-(4-chlorophenyl)ethanol is conducted in the absence of an added solvent.

18. The process according to claim 16 or 17, wherein said reacting hydrogen bromide with said 2-(4-chlorophenyl)ethanol is conducted by adding said hydrogen bromide to said 2-(4-chlorophenyl)ethanol.

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19. The process according to claim 16 or 17, wherein said reacting hydrogen bromide with said 2-(4-chlorophenyl)ethanol is conducted by adding said hydrogen bromide as a gas to said 2-(4-chlorophenyl)ethanol.

10 20. The process according to any one of claims 16 to 19, wherein said reacting hydrogen bromide with 2-(4-chlorophenyl)ethanol is conducted at a temperature from about 25 °C to about 110 °C.

15 21. The process according to any one of claims 16 to 19, wherein said reacting hydrogen bromide with 2-(4-chlorophenyl)ethanol is conducted at a temperature from about 60 °C to about 100 °C.

20 22. The process according to any one of claims 16 to 19, wherein said reacting hydrogen bromide with 2-(4-chlorophenyl)ethanol is conducted at a temperature from about 70 °C to about 90 °C.

25 23. The process according to any one of claims 16 to 22, wherein said reacting hydrogen bromide with 2-(4-chlorophenyl)ethanol is conducted at a pressure from about -1.00 bar to about +2.00 bar.

24. The process according to any one of claims 16 to 22, wherein said reacting hydrogen bromide with 2-(4-chlorophenyl)ethanol is conducted at a pressure from about -1.00 bar to about +0.50 bar.

30 25. The process according to any one of claims 16 to 22, wherein said reacting hydrogen bromide with 2-(4-chlorophenyl)ethanol is conducted at a pressure from about -0.85 bar to about +0.37 bar.

26. The process according to any one of claims 16 to 25, wherein after said reacting hydrogen bromide with 2-(4-chlorophenyl)ethanol, produces said 2-(4-chlorophenyl)ethyl bromide with a purity of about 95% or greater as determined by HPLC.

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27. The process according to any one of claims 16 to 25, wherein after said reacting hydrogen bromide with 2-(4-chlorophenyl)ethanol, produces said 2-(4-chlorophenyl)ethyl bromide with a purity of about 97% or greater as determined by HPLC.

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28. The process according to any one of claims 16 to 27, wherein said reacting 2-(4-chlorophenyl)ethyl bromide with 1-aminopropan-2-ol is conducted by the addition of 2-(4-chlorophenyl)ethyl bromide to 1-aminopropan-2-ol.

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29. The process according to any one of claims 16 to 28, wherein said reacting 2-(4-chlorophenyl)ethyl bromide with 1-aminopropan-2-ol is conducted by the addition of 2-(4-chlorophenyl)ethyl bromide to 1-aminopropan-2-ol at a rate such that 1-(bis(4-chlorophenethyl)amino)propan-2-ol is formed in an amount less than about 10% compared to 1-(4-chlorophenethylamino)propan-2-ol as determined by HPLC.

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30. The process according to any one of claims 16 to 28, wherein said reacting 2-(4-chlorophenyl)ethyl bromide with 1-aminopropan-2-ol is conducted by the addition of 2-(4-chlorophenyl)ethyl bromide to 1-aminopropan-2-ol at a rate such that 1-(bis(4-chlorophenethyl)amino)propan-2-ol is formed in an amount less than about 5% compared to 1-(4-chlorophenethylamino)propan-2-ol as determined by HPLC.

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31. The process according to any one of claims 16 to 30, wherein said reacting 2-(4-chlorophenyl)ethyl bromide with 1-aminopropan-2-ol is conducted in the presence of a molar excess of 1-aminopropan-2-ol compared to 2-(4-chlorophenyl)ethyl bromide.

30

32. The process according to any one of claims 16 to 31, wherein said reacting 2-(4-chlorophenyl)ethyl bromide with 1-aminopropan-2-ol is conducted at a temperature from about 60 °C to about 95 °C.

33. The process according to any one of claims 16 to 31, wherein said reacting 2-(4-chlorophenyl)ethyl bromide with 1-aminopropan-2-ol is conducted at a temperature from about 75 °C to about 90 °C.

5 34. The process according to any one of claims 16 to 33, wherein said reacting 1-(4-chlorophenethylamino)propan-2-ol with thionyl chloride is conducted in the presence of a solvent.

10 35. The process according to claim 34, wherein said solvent comprises toluene.

36. The process according to any one of claims 16 to 35, wherein said reacting 1-(4-chlorophenethylamino)propan-2-ol with thionyl chloride is conducted in the presence of dimethylacetamide.

15 37. The process according to any one of claims 16 to 36, wherein said reacting 1-(4-chlorophenethylamino)propan-2-ol with thionyl chloride is conducted at a temperature from about 55 °C to about 70 °C.

20 38. The process according to any one of claims 16 to 36, wherein said reacting 1-(4-chlorophenethylamino)propan-2-ol with thionyl chloride is conducted at a temperature from about 60 °C to about 65 °C.

25 39. The process according to any one of claims 16 to 38, further comprising a step of separating a water co-product from said 2-(4-chlorophenyl)ethyl bromide after step a) and prior to step b).

40. The process according to any one of claims 16 to 38, wherein after step a) the resulting mixture is used in step b) without substantial purification.

30 41. The process according to any one of claims 16 to 40, further comprising a step of removing 1-aminopropan-2-ol from the mixture after step b) and prior to step c).

42. The process according to claim 41, wherein said removing 1-aminopropan-2-ol from the mixture after step b) is conducted by the steps comprising:

adding water and an immiscible organic solvent to the mixture after step b) to form a biphasic mixture comprising an aqueous phase and an organic phase;

mixing said biphasic mixture and subsequently allowing to separate into said aqueous phase and said organic phase; and

5 removing said aqueous phase from said organic phase.

43. The process according to claim 42, wherein said immiscible organic solvent comprises toluene.

10 44. The process according to claim 42, wherein said immiscible organic solvent is toluene.

45. The process according to any one of claims 16 to 44, further comprising a step of crystallizing said 2-chloro-*N*-(4-chlorophenethyl)propan-1-amine hydrochloride after step c).

15 46. The process according to claim 45, wherein said crystallizing said 2-chloro-*N*-(4-chlorophenethyl)propan-1-amine hydrochloride is conducted in the presence of a mixture comprising a C₁-C₆ alcohol.

20 47. The process according to claim 45, wherein said crystallizing said 2-chloro-*N*-(4-chlorophenethyl)propan-1-amine hydrochloride is conducted in the presence of a mixture comprising isopropanol.

25 48. The process according to any one of claims 16 to 38, wherein steps a), b) and c) are conducted without substantial purification.

49. The process according to any one of claims 16 to 48, wherein said reacting 1-(4-chlorophenethylamino)propan-2-ol with thionyl chloride, produces said 2-chloro-*N*-(4-chlorophenethyl)propan-1-amine hydrochloride with a purity of about 95% or greater as determined by HPLC.

30 50. The process according to any one of claims 16 to 48, wherein said reacting 1-(4-chlorophenethylamino)propan-2-ol with thionyl chloride, produces said 2-chloro-*N*-(4-

chlorophenethyl)propan-1-amine hydrochloride with a purity of about 98% or greater as determined by HPLC.

INTERNATIONAL SEARCH REPORT

International application No
PCT/US2009/001340

A. CLASSIFICATION OF SUBJECT MATTER
INV. C07C17/16 C07C215/08 C07C209/68 C07C211/29
ADD. C07D223/16

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)
C07C

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

EPO-Internal, CHEM ABS Data

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y	WO 2007/120517 A (ARENA PHARM INC [US]; WEIGL ULRICH [DE]; PORSTMANN FRANK [CH]; STRAESS) 25 October 2007 (2007-10-25) cited in the application the whole document, especially synthetic scheme 1.1 -----	1-50
Y	JERRY MARCH: "Advanced Organic Chemistry; Reactions, Mechanisms and Structure; Third edition" 1985, JOHN WILEY & SONS (WILEY-INTERSCIENCE PUBLICATION) , NEW-YORK , XP002527116 pages 382-384 ----- -/-	1-50

Further documents are listed in the continuation of Box C.

See patent family annex.

* Special categories of cited documents :

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- "Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.
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INTERNATIONAL SEARCH REPORT

International application No
PCT/US2009/001340

C(Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y	CAREY, F AND SUNDERG, R.: "Advanced Organic Chemistry, Part B: Reactions and Synthesis, second edition" 1983, PLENUM PRESS , NEW YORK , XP002527117 pages 96-98 -----	1-50

INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No
PCT/US2009/001340

Patent document cited in search report	Publication date	Patent family member(s)	Publication date
WO 2007120517	A 25-10-2007	CA 2646044 A1 EP 2001852 A2	25-10-2007 17-12-2008